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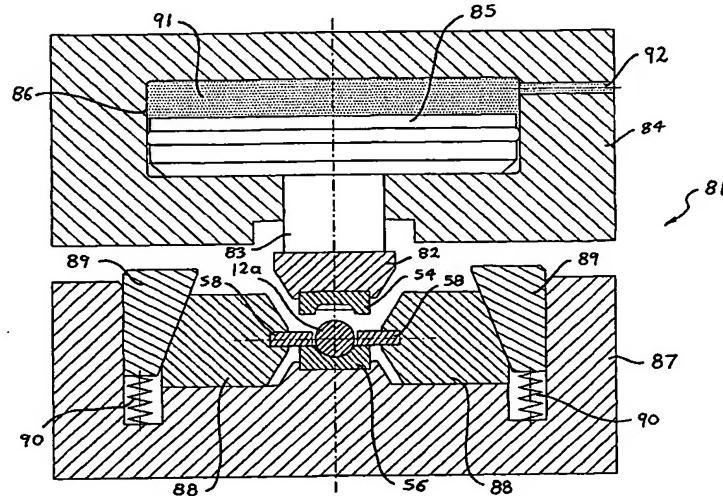
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**(54) Title:** STEERING RACK MANUFACTURE



**(57) Abstract:** A die apparatus and method for performing a flashless forging operation to manufacture the toothed portion of a steering rack. The die apparatus comprising first and second die members and at least one punch member, each having a forming surface shaped substantially as the obverse of a portion of said toothed portion, and at least a portion of the forming surface of said first die member being shaped substantially as the obverse of the teeth of said rack. Said first and second die members being moveable towards each other to a closed position thereby partially forging said toothed portion from a blank placed in said die apparatus and forming a substantially closed cavity defined by said forming surfaces, said punch member being adapted to move into said cavity, once said die members are in said closed position, thereby completing said forging operation.

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